



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2125

Job Sheet 199984

(2) PL



POSITIVE RECALL

Part No: D2125

Job Qty: 7 pcs

EFFECTIVE 19.08.25 AUTH D

Part Name: Replacement Exterior Window For -015



RELEASED 6 DATE 19.12.09

Part Weight: 0 lbs

Status: New first time supplier Priority: Medium

Job Created: 9/5/19

Job Tracking No:

Due Date: 9/26/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP: D 05.10.14 Added bold comments on step 5/6 & cellophane on step 7 KJ/EC IPP E 07.05.29
thermoformed in-house EC IPP F 07.09.28 rev C dwg EC verified by:DD IPP Rev G 14/01/20 Change "Folio"
to Work Instruction DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Workcenter / Supplier Lead Time
					Setup Hrs	Run Hrs		
110	Purchasing	2 pcs	9/26/19	9/26/19	0.00	0.00	Purchasing - 1	10 OCT 09 2019
							Purchasing - 2	
							Purchasing - 3	
140	Packaging 2-1 - Receive - B4B	2 pcs	9/26/19	9/26/19	0.00	0.00	Packaging 2 - 1 - B4B	10 OCT 09 2019
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S221291



Part: D2125

Job No: 199984

Serial No/Batch: S221291

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/09/19

Plex 9/5/19 12:54 PM Dart.lajeunesse.marie

				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
150 QC 6	2 pcs	9/26/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
				QC 6 - 81	
170 Packaging 3-1 - Stock - B4B	2 pcs	9/26/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	2 pcs	9/26/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

DAS
DEC 09 2019 40
9-89

ML

DAS
21
DEC 09 2019

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9
9-89
POSITIVE
RECALL

Part Op 140 - Receive & Inspect for Damage & Mat'l Certs
 Descriptions: 150 - QC6- All purchased or subcontracted products
 170 - Identify as per dwg & Stock Location: _____
 180 - QC21- Final Inspection - Work Order Release

POHB044525 x 2 *ML* 17 SEP 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2125P	Replacement Exterior Window For -015	2 pcs (1 ea)	110-Purchasing	S-221286.
MACRLICS.125	1/8" Polycast li Sheet	32 sf (16 ea)	110-Purchasing	S-157992.

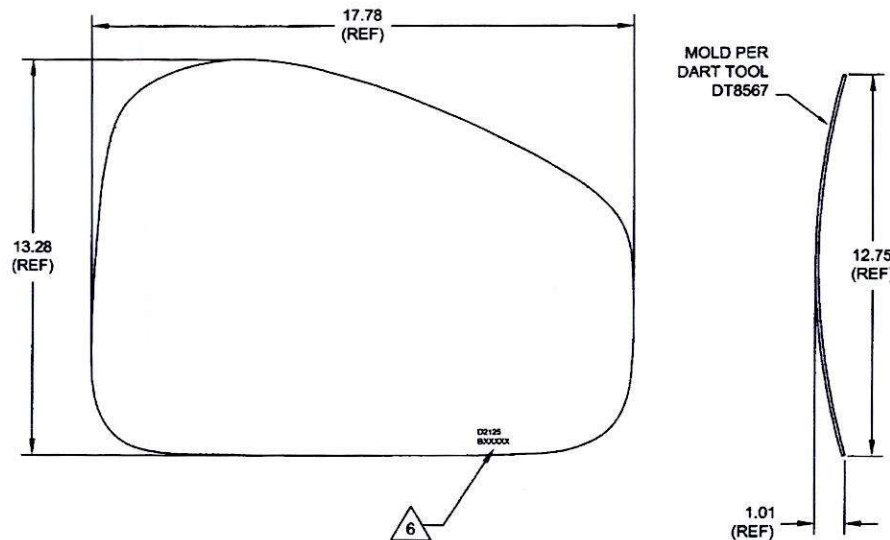
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D2125P	2	0	0
	MACRLICS.125	32	1,567	0

Part Specifications

Specifications could not be found.

Plex 10/9/19 1:13 PM dart.lussier.patrick



D2125 FLOOR WINDOW
(FLAT TEMPLATE)

D2125 FLOOR WINDOW:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D2125" AND B/N ON LOWER EDGE USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 0.98 +/- 0.22 LBS
- 8) FLAT ROUGH SIZE: 13.3 x 17.8 x 0.13
- 9) MOLD PER DART TOOL DT8567

SHOP
RETURN
ENGINEER
UNCONTROLLED
SUBJECT TO AMEND
WITHOUT NOTIC
WORK ORDER
NO. 199984 MJS
19-09-05

RELEASED
07.09.22

C	REDRAWN PER PAR 187	DC	07.07.18
B	CREATE DWG. UPDATE MTL PER NCR 029	MB	08.04.19
A	ADDED PICTURE WITH OVERALL DIMS	KE	99.03.09
-	NEW ISSUE	BW	92.03.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DE		
CHECKED	JB	DRAWING NO.	REV. C
MFG. APPR.	JB	D2125	SHEET 1 OF 1
APPROVED	JB	TITLE	SCALE
DE APPR.	JB	350/355 FLOOR WINDOW	NTS
DATE	07.07.18	COPYRIGHT © 1992 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		
Date :	Sequence #:	QTY Affected :	MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By
				Lead hand / Supervisor
				QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function		FAULT CATEGORY ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		
Other/Details:				



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044525



Supplier: PTF001-VC
Plas-Tech Fabrications
128 Walgreen Road
Ottawa
ON
K0A 1L0 Canada
Phone: 613-831-4640
Fax: 613-831-4624

PO No: POHB044525
PO Date: 9/17/19
Due Date: 9/24/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

POSITIVE RECALL
EFFECTIVE 19.09.23
RELEASED
first time
DATE
5-pp: on

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	199984	D2125P			Replacement Exterior Window For -015 : Various STC's REV C	Firmed X2		9/24/19	2 pcs	0 pcs	2 pcs	\$0.01/pcs	\$0.02
2	199343	D3752-1P			Seat Frame : Various STC's receive pcs REV C	Firmed XI		9/24/19	1 pcs	0 pcs	1 pcs	\$0.01/pcs	\$0.02
Grand Total:													\$0.04

Order Notes

Procurement Quality Clauses

A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/17/19 11:09 AM dart.lussier.patrick

Plas-Tech Fabrications Inc.

128 Walgreen Rd
Stittsville, Ont
K0A 1L0

Ph: 613-831-4640
Fx: 613-831-4624

Packing Slip

Packing Slip No.:

37580

Date:

Oct 08, 2019

Page:

1

Sold to:	Ship to:
DART AEROSPACE MICHAEL GREGOIRE 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7	DART AEROSPACE 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7 PO HB044525
Order No.: 22833	Sold By: Mark Perry
Shipped By:	Ship Date: Oct 08, 2019
Tracking No.:	

Item No.	Unit	Description	Quantity
MISC	Each	REPLACEMENT EXTERIOR WINDOW FOR -015 D2125 REV C.	2
RECEIVED OCT 09 2019 DART AEROSPACE LTD.			
Comment: Thank you for your order.			



128 WALGREEN ROAD
CARP. ON K0A 1L0
PHONE-613-831-4640
FAX-613-831-4624

CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: October 9, 2019

YOUR PURCHASE ORDER: PO HB044525

OUR INVOICE NO: 37580

LINE ITEM # 1

QUANTITY: 2

DESCRIPTION: REPLACEMENT EXTERIOR WINDOW FOR -015 D2125 REV C.

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH:

DART QSI 018

PLASTECH PROCESS PR-01-01-D2125 REV 1.0 USING DWG D2125 REV C.

Note: USED 1 SHEET - 32 SF OF PLEXIGLASS G CLEAR CAST ACRYLIC SHEET PER LP-391
TYPE 1 GRADE C, 0.125 THICK (REF DART SPEC. M-ACRYLIC-S.125). BATCH# S151992.

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF
THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT
SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS
AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE

A handwritten signature in blue ink, appearing to read 'Mark Perry', is written over a horizontal line.

MARK PERRY, M.ENG.
PRESIDENT

DAS
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9-89

Form 2: Product Accountability – Raw Material, Specifications and Special Process(es), Functional Testing

1. Part Number D2125	2 Part Name 350/355 FLOOR WINDOW		2. Serial Number 2019-001		4. FAI Report Number FAIR-D2125 Rev C
5. Material or Process Name	6. Specification Number	7. Code	8. Special Process Supplier Code	9. Customer Approval Verification (Yes/No/NA)	10. Certificate of Conformance number
PLEXIGLAS G CLEAR CAST ACRYLIC SHEET	LP-391 TYPE 1 GRADE C, 0.125 THICK REF. DART SPEC. M-ACRYLIC-S.125		N/A	N/A	N/A Supplied by Customer_DART
11. Functional Test Procedure Number	12. Acceptance report number, if applicable				
13. Comments					
14. Prepared By Mark Perry Plas-Tech Fabrications			15. Date 10-08-2019		

SAE AS9102 First Article Inspection Form

Form 3: Characteristic Accountability, Verification and Compatibility Evaluation

Sheet 1 of 2

1. Part Number D2125				2. Part Name Floor Window			3. Serial Number 2019-001	4. FAI Report FAIR-D2125 Rev C
Characteristic Accountability				Inspection / Test Results				
5. Char No.	6. Reference Location	7. Characteristic Designator	8. Requirement	9. Results	10. Designed Tooling	11. Non-Conformance Number	14. Remarks.	
1	7B-SH1, Eng. Note 1		MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125	CHECKED Plexiglas G Acrylic sheet .125			Material supplied by customer _ Dart Material M-ACRYLICS.125 Batch# 5151992.	
2	7B-SH1, Eng. Note 2		FINISH: NONE	NOTED				
3	7A-SH1, Eng. Note 3		TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED	NOTED				
4	7A-SH1, Eng. Note 4		UNITS: INCHES UNLESS OTHERWISE NOTED	NOTED				
5	7A-SH1, Eng. Note 5		REMOVE SHARP EDGES	SCRAPED BOTH EDGES TO REMOVE.				
6	5C & 7A-SH1, Eng. Note 6		IDENTIFICATION: ENGRAVE P/N "D2125" AND 8/N ON LOWER EDGE USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"	NOTED			- Tag or label only by Plas-Tech - Final Identification to be completed by Dart per Eng. Note 6.	
7	7A-SH1, Eng. Note 7		WEIGHT: 0.98 +/- 0.22 Lbs.	1 LB			PLASTECH WEIGH SCALE IS +/- 1 LB ACCURACY.	

Form 3: Characteristic Accountability, Verification and Compatibility Evaluation

Sheet 2 of 2

4. Part Number D2125				5. Part Name Floor Window		3. Serial Number 2019-01	4. FAI Report FAIR-D2125 Rev C
Characteristic Accountability				Inspection / Test Results			
5. Char No.	6. Reference Location	7. Characteristic Designator	8. Requirement	9. Results	10. Designed Tooling	11. Non-Conformance Number	14. Remarks.
8	7A-SH1, Eng. Note 8		FLAT ROUGH SIZE: 13.0 X 17.8 X 0.13	LENGTH: SEE #12 WIDTH: SEE #11 THICKNESS: 0.122			
9	4D & 7A-SH1, Eng. Note 9		MOLD PER DART TOOL DT8567	NOTED	MOULD DT8576		
10	7C-SH1		13.28 +/- 0.030 REF	13.22			TRIMMED POST HEAT
11	5D-SH1		17.78 +/- 0.030 REF	17.81			TRIMMED POST HEAT
12	3C-SH1		12.75 +/- 0.030 REF	13.16			TRIMMED POST HEAT
13	4C-SH1		1.01 +/- 0.030 REF	0.63			CONTROLLED BY MOULD. PART CONFORMS TO MALE MOULD WITHOUT ANY GAPS POST COOLING.
14	GENERAL		WORKMANSHIP	COMPLIANT			VISUAL AND CHECK FOR SCRATCHES / CLARITY.

The signature indicates that all characteristics are accounted for; meet drawing requirements or are properly documented for disposition.

12. Prepared By Mark Perry, Plas-Tech Fabrications

13. Date 10-8-2019

Plas-Tech Fabrications

128 Walgreen Road
Ottawa, Ontario K0A 1L0
Canada

INVOICE

Invoice No.: 37580
Date: Oct 08, 2019
Page: 1
Re: Order No. 22833

Sold to:

DART AEROSPACE
MICHAEL GREGOIRE
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7

Ship to:

DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
PO HB044525

Business No.: 890292097

Item No.	Unit	Quantity	Description	Tax	Unit Price	Amount
MISC	Each	2	REPLACEMENT EXTERIOR WINDOW FOR -015 D2125 REV.C.	H	287.50	575.00
			H - HST 13% HST			74.75
Shipped By _____ Tracking Number: _____					Total Amount	649.75
Terms: Net 30 Due Nov 07, 2019.						
Comment: Thank you for your order.						